



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D119-696-013
Job Sheet 178620



Part No: D119-696-013

Job Qty: 2 ea

Part Name: Dual Mirror Installation

JUN 07 2018



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/5/18

Job Tracking No:

Due Date: 6/8/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG IIN-D119-696 REV A SHEETS 5,6,7, DSI9578 REV A IPP Rev:A 08-02-19 New issue DD verified by: LL
IPP REV:B 11.01.19 AS PER CHG005 DD VERF:EC IPP REV:C 11.11.14 AS PER CHG006 DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		6/8/18	0.00	0.00	Start Up Stores/Pkg-1		6/17/2018 JUN 27 2018
110	Packaging	2 pcs		6/8/18	0.00	0.00	Packaging1-1		JUL 02 2018
120	QC	2 pcs		6/8/18	0.00	0.00	QC4		
125	DC	2 pcs		6/8/18	0.00	0.00	DC		
130	Packaging	2 pcs		6/8/18	0.00	0.00	Packaging3-1		
140	QC21-FG	2 Ea		6/8/18	0.00	0.00	QC21		DAS 21 JUL 04 2018

Part Op 110 - Pick Kit

Descriptions: 120 - QC4- 100% Inspect kits for completeness

125 - Document Control Photocopy bluefile & type labels per PPP D119-696-013 CHG006

130 - Identify as per dwg & Stock Location: Fg. Identify and pack for shipping as per PPP D119-696-013 LOCATION: FG016

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
ALS4-1032-130	Rivnut	4 Ea (2 ea)	90-Start up Operation	3007279
AN526-1032R9	Screw	8 Ea (4 ea)	90-Start up Operation	FM137736-4
D119-696-043	Dual Cargo Mirror Assembly, 6 Inch Round	2 Ea (1 ea)	90-Start up Operation	5081025
D2053	Bracket	2 Ea (1 ea)	90-Start up Operation	5027177
D2067	Connector 5084596 x 1	2 Ea (1 ea)	90-Start up Operation	7105444 x 1
D2071	Cable Assembly - 32"	2 Ea (1 ea)	90-Start up Operation	5072096
D3083-1	Placard	2 Ea (1 ea)	90-Start up Operation	5062869
MS21919-DG5	Clamp	4 Ea (2 ea)	90-Start up Operation	5041536
MS27039-1-09	Screw	8 Ea (4 ea)	90-Start up Operation	5017101
MS35489-9	Grommet	2 Ea (1 ea)	90-Start up Operation	FM136044
NAS1149D0363J	Washer	8 Ea (4 ea)	90-Start up Operation	5015269



Container No: S084673



Part: D119-696-013

Job No: 178620

Serial No/Batch: S084673

Revision: A/A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/27/18

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	ALS4-1032-130	4	13,674	0
	AN526-1032R9	8	76	0
	D119-696-043	2	0	0
	D2053	2	8	0
	D2067	2	1	0
	D2071	2	16	0
	D3083-1	2	2	0
	MS21919-DG5	4	14	0
	MS27039-1-09	8	162	0
	MS35489-9	2	36	0
	NAS1149D0363J	8	2,587	0
Part Specifications				
Specifications could not be found.				

Plex 6/5/18 9:28 AM dart.lacelle.linda

PAGE 1 OF 1

Description: CARGO MIRROR INSTALLATION

H:\Forms\Engineer\Approved Eng Online\CHGREC revB

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			

REFERENCE ONLY

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-696-011	2.2 lb	7.0 in	15.4 in-lb	22.0 in	48.4 in-lb
Cargo Mirror Installation	1.00 kg	0.28 m	0.28 m-kg	0.87 m	0.87 m-kg
D119-696-013	3.0 lb	1.0 in	3.0 in-lb	22.0 in	66.0 in-lb
Cargo Mirror Installation	1.36 kg	0.04 m	0.05 m-kg	0.87 m	1.18 m-kg

5. PARTS LIST

Qty -011	Qty -013	Qty -041	Qty -043	Part Number	Description
X				D119-696-011	SINGLE CARGO MIRROR INSTALLATION
	X			D119-696-013	DUAL CARGO MIRROR INSTALLATION
1		X		D119-696-041	SINGLE CARGO MIRROR ASSEMBLY
	1		X	D119-696-043	DUAL CARGO MIRROR ASSEMBLY
		1	2	D2011-101	MIRROR ASSEMBLY
1	1			D2053	BRACKET
		2	2	D2054	BUSHING
		2	2	D2055	CLAMP
		1	1	D2056	BELL CRANK
		1		D2057	PLUG
1	1			D2067	CONNECTOR
1	1			D2071	CABLE ASSEMBLY
		1	2	*D3014-1	LOCKNUT
		1	1	D3072-1	BRACKET
		1	1	D3072-2	BRACKET
		1		D3074-1	ARM
			1	D3074-3	ARM
1	1			D3083-1	PLACARD
4	4			AN526-1032R9	SCREW
4	4	6	6	AN960JD10	WASHER
		1	2	*AN960JD416L	WASHER
		3	3	MS21042L3	NUT (or MS21042-3)
2	2			MS21919DG5	CLAMP
4	4			MS27039-1-09	SCREW
		3	3	MS27039-1-18	SCREW
1	1			MS35489-9	GROMMET
2	2			AKS7-1032-130	INSERT (or ALS7-1032-130 or AKS4-1032-130 or ALS7-1032-130 or AELS-032-130)

*INCLUDED AS PART OF D2011-101 MIRROR ASSEMBLY

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Revision: A

Date: 01.12.11